Work Order September-11-13		D 2 1 5 B 1 0 6 8		* 1	1068	61*	; ; ;		The second secon		2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2 2	Page 1
Revision ID:	2150 acker Doubler, Hinge	REVA		Accept	*	N900	040	100) * 5	Setup Star	I VI	S1* S2*
	/20/13 Start (Qty: 20.00 Qty: 20.00	*20* *20*			Cust Item Customer:	ID:				14	
Approvals: I	Process Plan:		Date: \\3~\\^\	しTooling:		D	ate:		F	Run Star	1/1	R1*
	QC:				i):	D	ate:			Stop	*N	R2*
Sequence ID/ Work Center ID	Operat Descrip			Set Up Run H		Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
Draw Nbr	Revision Nb	r										
D2150	Rev A											
*100	FLOW V	ATER JET		0.00					2	2	•	4.
Waterjet FLOW CNC Waterjet		Memo 1-Cut as per Do Deburr if neces		0.00 A Prog I	Rev: 2	- *				<u> </u>	•	13.11.03
2024 040		2000	·,			•						
110	QC2- Ins	pect parts off mac	nine FAI/FAIB	0.00	gro.							1
110 QC Quality Control		Memo		0.00	Ü				20		-	13.11.03
120	QC8- lns	pect parts - second	check	0.00	DAS 27 9-89				\sim			
1'20 QC Quality Control		Memo		0.00	311.04				₩			

NOV 1 2 2013

						•				DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	O	NFORM	ANCE / UP	DATE			
										QA Closed:	Date	:
Work Orde	ari.			•	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK OIGE					Rework	ıİ		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.				Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			·		Use-as-is		Therm	noforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	lo				Work Order Update			Large Fab	Composite	j	Supplier	
Root				Descri	ption of work order update	1	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data								ı				
Equip/Tooling											!	1
Operator		1								}		
Material												
Setup						l						
Other												
Process		İ									İ	}
Supplier												
Training												
Unapproved		<u> </u>				<u> </u>						
					F,	AUL	T CATE	GORY				
Landi	ng Gear			_	General					-	-	
	Bendin	3			Bend	<u> </u>	Grain			Ovalized	L	Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route	_	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			L	Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
	Crushe	d/Crimped	l	L	Burrs		1	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	\perp	Mainte	nance		Part Moved		
	Heat Tr	eat			Countersink		Mislabe	led		Positioned \	Vrong	_
	Inspect	ion Strip ir	n Tube		Cut Too Short		Misread	I		Power Loss/	Surge	Other
	Ripples	in Bend			Drill Holes	1	Offset					

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Ord September-11-1				*	10686	31*					Page 2	
Item ID: Revision ID: Item Name:	D2150 Packer Doub	oler, Hinge		Accept	*	1 900	04010	n* s	Setup Star Stop	ı Vı	S1*	
Start Date: Required Date: Reference:	9/20/13 : 9/20/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item I Customer:	D:					
Approvals:	Process P	lan:	Date:	_ Tooling: _ SPC (Y/			ate:	I	Run Star Stop	171	R1* R2*	
Sequence ID/ Work Center I 130 *120* Small Fab Small Fab	D	Operation Description Small Fab Memo Deburr		Set U Run I 0.00		DAS 27 9-89	Tool # Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*140 *140 HandFinish Hand Finishing		Chemical Conversion Con Memo	at per QS1005 4.1	0.00				20	M	3.11	. 8	
150 *150* Powdercoat		White Gloss(Ref.4.3.5.1)	per QSI005 4.3-Alum	0.00				20	ф	1311-12	<i>2</i>)as 34)-89

Memo

Powder Coating

SARTAME: OVEN TEMPERATURE:

										DQA:	Date:	
NCR: Y	'es / No				WORK ORDER NON-C	ON	IFORN	MANCE / UPE	DATE	QA Closed:	 Date:	
						_				QA Closed:	Date	·
Work Orde	· ·				DISPOSITION	- 1			AGAINST DE	PARTMENT	/PROCESS	
work Orde					Rework	1		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	lo.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is			oforming	Finishing	4	re/Packaging	Other
NCR N	lo	<u></u>			Work Order Update	1		Large Fab	Composite]	Supplier	
Root				Descri	ption of work order update	li	nitial	Act	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling						1						
Operator						Į.					ļ.	
Material								•				
Setup												
Other												
Process												
Supplier												
Training												
Unapproved											1	
					F	AUL	T CATE	GORY				
Landi	ng Gear				General	_	•			_		- -
	Bending				Bend		Grain			Ovalized	<u></u>	Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route	Ш	Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks			ļ	Broken/Damaged	Ш	Inspecti	on Incomplete		Part Incorre	ct	Weld
	Crushed	/Crimped			Burrs	Ш	Instruct	ions Incomplete/U	Jnclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved		
	Heat Tre	eat			Countersink		Mislabe	led		Positioned \	Wrong	_
	Inspecti	on Strip ir	Tube		Cut Too Short		Misread	I		Power Loss,	/Surge	Other
	Ripples	in Bend			Drill Holes		Offset		-			

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Work Ord September-11-1				*	10	6861*						Page	3
Item ID: Revision ID: Item Name:	D2150 Packer Doub	oler, Hinge	,	Accept		*N900	040	100)* 5	Setup Sta	IZI	S1* S2*	
Start Date: Required Date Reference:	9/20/13 : 9/20/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*			Cust Item I Customer:	D:						
Approvals:	Process P QC:	lan:	Date:	Tooling SPC (Y			ate:		I	Run Sta Sto		R1* R2*	
Sequence ID/ Work Center I	D	Operation Description		Set U Run	Jp/ Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
*160 *160* QC Quality Control		QC3- Inspect Part Finish Memo		0.00	DAS 16 9-89	13/11/13		(0	ntes (20)			·	
170 * 17 0*		Identify as per dwg & Stoo	ck Location: <u>STO</u> 04	0.00					20			DAS 33 _9-89	13-11-13
Packaging		Memo		0.00								_ y- 69	-

180

Packaging

QC21- Final Inspection - Work Order Release

0.00

*1 **2**0*

Memo

0.00

Quality Control

13/11/14 dd mF 11-13

												DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	/ANCE / UF	PDATE					
												QA Closed:	Da	te:	
Work Orde	or.					DISPOSITION				AGAINST I	DE	PARTMENT,	/PROCESS		
Part I	۔ ِ .oV	-				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		4	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
	•					· <u>-</u>	_		· ·	· •					
Root					Descri	ption of work order update		Initial	A	ction		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ct	nief Eng	Des	cription		Date	Verificatio	n	QC inspector
Doc/Data									·						
Equip/Tooling															!
Operator			ļ												
Material															
Setup												ļ			
Other															
Process	L							:							
Supplier	L			ļ											
Training	L														
Unapproved			<u> </u>												
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Landi	ing (Gear				General		-		,		,			1
		Bending			<u></u>	Bend		Grain				Ovalized			Pressure/Forced
		Centre N	ot Concei	ntric to	o/s	BOM/Route	L	Hardwa	re	}		Over/Under	tolerance	L	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspecti	on Incomplete	ļ		Part Incorre	ct		Weld
		Crushed/	Crimped			Burrs	L	Instruct	ions Incomplete	/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
		Cuffs				Contamination -		Mainte	nance			Part Moved			
		Heat Trea	at			Countersink		Mislabe	led			Positioned V	Vrong		_
}		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i			Power Loss/	Surge		Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

September-11-13 11:47:25 AM

Work Order ID:

106861

Parent Item:

D2150

Parent Item Name:

Packer Doubler, Hinge

Start Date: 9/20/13

Required Date: 9/20/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP C00.11.27Re-format (mpp 2101)EC IPP Rev:D 06-08-23 Now on Waterjet

 $\mathbf{H}\mathbf{M}$

	IPP Rev:D U6-U8	-23 NOW OIL W	aterjet	JLiVI									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No	· · · · · · · · · · · · · · · · · · ·		100	sf	275.4477	0.025	(0.526316	Au	13:	11.03
				Location		Loc Oty	<u>Lo</u>	c Code					
				MAT022		275.4476922							
				12060	05	65.8254832							
				12119	97	57.187894							
				12213	36	31.78							
				1232	17	20.094315						_	21
				1249	87	100.56			12	4487		• • •	41

									DQA:	Date:	
NCR: Y	es / No				WORK ORDER NON-C	ONFORM	MANCE / UP	DATE	QA Closed:	Date:	
						1			QA Closed.	Date.	
Work Orde	or-				DISPOSITION	1		AGAINST DE	PARTMENT	/PROCESS	
Work Orde					Rework		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.				Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is		noforming	Finishing	i .	re/Packaging	Other
NCR N	lo			····	Work Order Update		Large Fab	Composite	•	Supplier	
Root		T		Descri	ption of work order update	Initial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
Equip/Tooling											
Operator			,								
Material											
Setup		İ	i								
Other								,			
Process		ļ									
Supplier											
Training								•			
Unapproved						<u> </u>					
					F/	AULT CATE	GORY				
Landi	ng Gear				General		•		7		7
	Bending				Bend	Grain			Ovalized		Pressure/Forced
	Centre N	lot Conce	ntric to	o/s	BOM/Route	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Inspect	ion Incomplete		Part Incorre	ct	Weld
	Crushed,	/Crimped			Burrs	Instruct	ions Incomplete/	Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs				Contamination	Mainte	enance	<u></u>	Part Moved		
	Heat Tre	at		ļ	Countersink	Mislabe	eled		Positioned V	Wrong	-
	Inspection	on Strip in	Tube		Cut Too Short	Misread	t		Power Loss/	'Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	106861
Description: Packer	Part Number:	D2150
Inspection Dwg: D2150 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X	First Article	Prototyp	е
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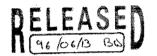
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.740	+/-0.010	740			V	JKM-01
2.050	+/-0.010	2.050	/		V	
0.231	+/-0.010	,231	(V	
1.217	+/-0.010	1,217	(V	
1.559	+/-0.010	1.559	1		V	
2.300	+/-0.010	2.300	1		V	
1.560	+/-0.010	1.560	1		V	
0.250	+/-0.010	1250	(V	
1.328	+/-0.010	1.328	1		V	
0.342	+/-0.010	342	_		V	
Ø0.098	+0.005/-0.000	100	_		V	
Ø0.171	+0.005/-0.000	.170	_		V	
0.040	+/-0.010	039			V	
		·				·

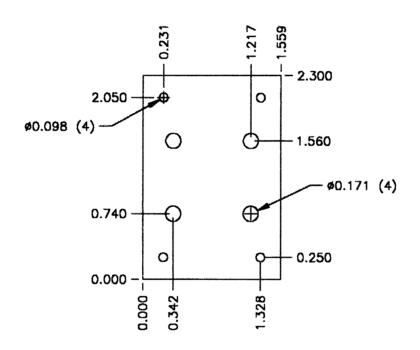
		DAS		
Measured by:	Audited by:	27	Prototype Approval:	N/A
Date: /3/11.03	Date:	B114	Date:	N/A

Rev	Date	Change	Revised by Approved
Α	04.09.28	New Issue	KJ/JLM KJ/JLM



DESIGN B WILLIAMS	drawn by K HAND	DART AEROSPACE LT VICTORIA INTERNATIONAL AIRPORT, CANAE	
CHECKED	APPROVED	DRAWING NO.	REV. A
Bu	BU	D2150 sh	EET 1 OF 1
DATE		TILE	SCALE
95:05:01		PACKER	1:1





MATERIAL: 2024-T3, 0.040 THICK FINISH: WHITE POWDER COAT HI-GLOSS